

6006176 3.0

5.061 inch

Work Order ID 150829

150829

Page 1

Thursday, September 08, 2016 9:03:52 AM

Item ID: D5149-1TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Step Base Turning Detail

Start Date: 09/12/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/16/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5149	D

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Doosan

Memo

1.27

Doosan Lathe

Turn blank as per Folio FB355

10 0 16-11-14

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

10 0 16-11-14

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.03

Quality Control

B = 16/11/15

10 0 16-11-14

DAS
08
9-09

Work Order ID 150829***150829***

Page 2

Thursday, September 08, 2016 9:03:52 AM

Item ID: D5149-1TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Step Base Turning Detail

Start Date: 09/12/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/16/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

D.P. 16-11-15

10

0

DAS
08
9-09

Packaging

LOCATION: MAT060

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.17

DAS
21
9-09

NOV 15 2016

Quality Control

16-11-16

Picklist Print

Thursday, September 08, 2016 9:03:51 AM

Page 1

Work Order ID: 150829

150829

Parent Item: D5149-1TRN

D5149-1TRN

Parent Item Name: Fwd Step Base Turning Detail

Start Date: 09/12/2016

Required Date: 09/16/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.000		Purchased	No				f	0.4000		4.378947			

M6061T6R3 000

**

6061-T6 RD BAR 3.000"

Location

Loc Qty

Loc Code

MAT012

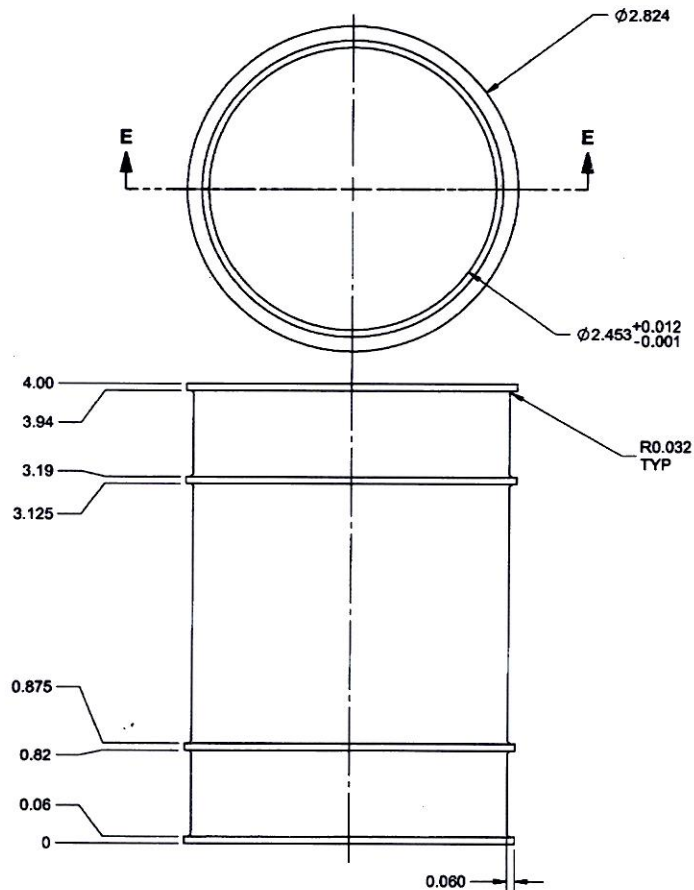
0.4

M135689

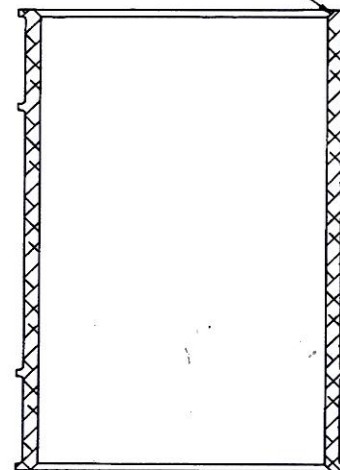
0.4

M135689

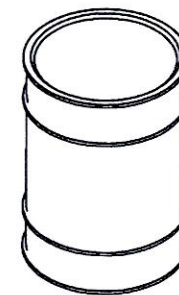
504' 16-11-14



0.060 X 45° CMF
TYP



SECTION E-E



w/0150829

D5149-1TRN TURNING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.41 lbs

RELEASED
2015-11-04

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D5149	SHEET 9 OF 11
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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